

Date: Tuesday, 2/26/2008 8:02:15 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 37634	
Estimate Number : 12594	
P.O. Number :	Part Number : D30417
This Issue : 2/26/2008 S.O. No. :	Drawing Number : D3041REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 29687	Material :
Written By :	Due Date : 3/14/2008 Qty: 20 Um: Each
Checked & Approved By : <u>08 02 26</u>	
Comment : Est:A 01.07.11 New Issue SM/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.1094 f(s)/Unit Total : 2.1882 f(s)
Lug Extrusion
(D2423) Batch: B33310 C08/02/27 (20)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut D2423 Extrusion: 1.250" Long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
Check for cracks while loading into the machine
Machine as per Follo FA and Dwg D3041
Tumble and Deburr rough edges after tumbling
Identify as D3041-7

N/A
7/26/08 03-11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

1.1 *ISSUE P/O: 5798* *C08/02/26* (20)
GLOBUS.

1.2 * *NEEDIVE AND ATTACHING CRIT* *08/3/10* (20)

Page 1 1.3 *QC6.* *08/03/11* (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 08/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CLAMP

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Part Number: D30417

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



20X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-a

08/03/11

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m 107005

08/03/11

20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



20X

Comment: INSPECT POWDER COAT

m-a

08/03/12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *465*

8/3/12

50

20X

10.0

QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

12/08/03/12

Job Completion



mini 2008/3/12

20

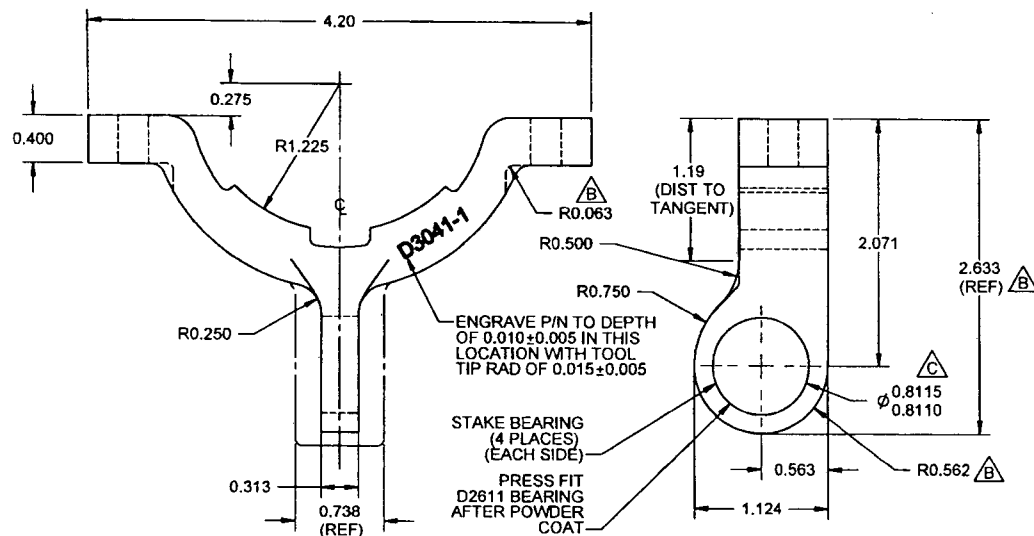
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

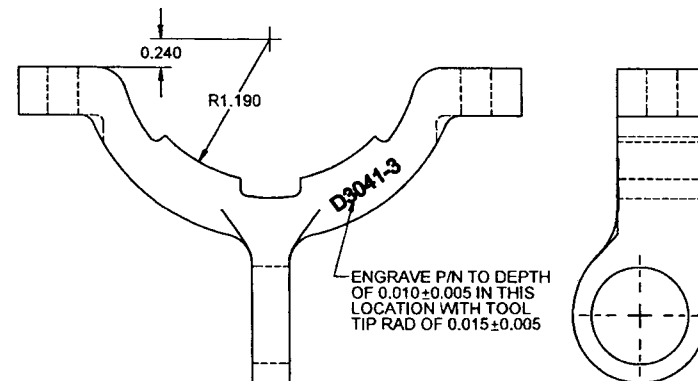
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

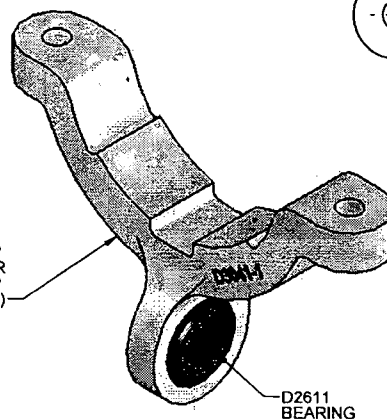
NOTE: Date & initial all entries



D3041-1 CLAMP



D3041-3 CLAMP
(SAME AS D3041-1
EXCEPT AS SHOWN)



NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) STAKE D2611 BEARING AFTER POWDER COAT
- 7) PART IS SYMMETRIC ABOUT C

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NO. 37634

RELEASED

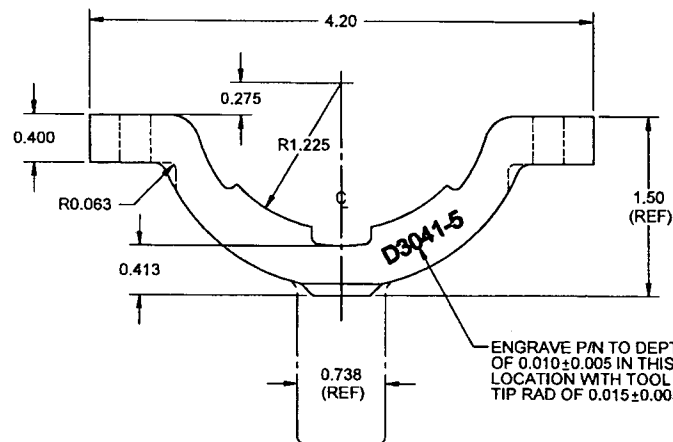
06.11.17

C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5/-7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	PORT HADLOCK, WA
DATE	06.10.18	DRAWING NO. D3041
		TITLE CLAMP
		REV. C
		SHEET 1 OF 2
		SCALE 1:1

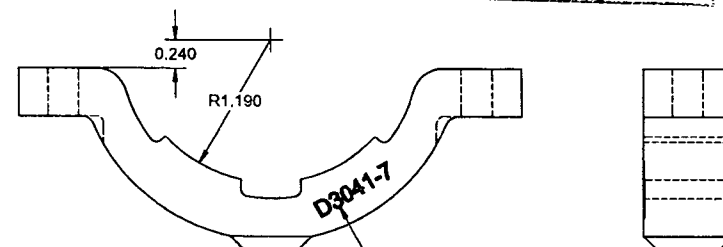
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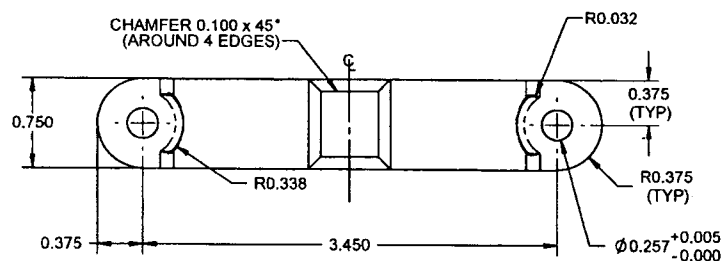
06.11.17



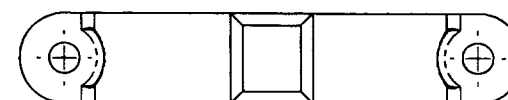
ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005



ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005



D3041-5 CLAMP

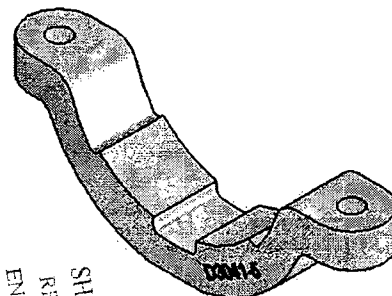


D3041-7 CLAMP
(SAME AS D3041-5 EXCEPT AS SHOWN)

NOTES:

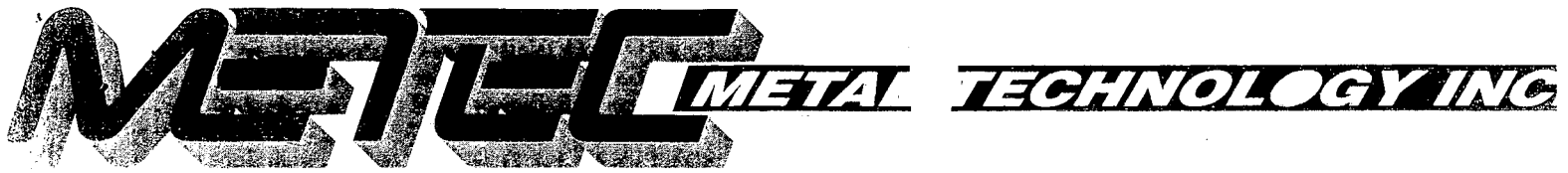
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- 6) PART IS SYMMETRIC ABOUT C

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WITHOUT NOTICE
WORK ORDER
37634



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	PORT HADLOCK, WA	
DATE	DRAWING NO.	REV. C	
06.10.18	D3041	SHEET 2 OF 2	
	TITLE	SCALE	
	CLAMP	1:1	

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	D3041-5	Clamp	5798
20	D3041-7	Clamp	5798

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Denise Robinson", with a long horizontal line extending to the right.

Denise Robinson

Vankleek Hill, March 7, 2008